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AS ENCLOSED TO IPRP**IP20 Rec'd PCT/PTO 12 MAY 2006**

We claim:-

- 5 1. A process for the production of flexographic printing plates by thermal development, in which the starting material used is a photopolymerizable flexographic printing element which comprises, arranged one on top of the other, at least

- 10 • a dimensionally stable substrate,
- at least one photopolymerizable relief-forming layer, at least comprising an elastomeric binder, ethylenically unsaturated monomers, plasticizer and photoinitiator,

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and the process comprises at least the following steps:

- (a) imagewise exposure of the photopolymerizable relief-forming layer to actinic radiation,
- 20 (b) heating of the exposed flexographic printing element to a temperature of from 40 to 200°C,
- (c) removal of the softened, unpolymerized parts of the relief-forming layer with formation of a printing relief,
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wherein the elastomeric binder is at least one styrene/butadiene block copolymer having a molecular weight M_w of from 80 000 to 250 000 g/mol and a styrene content of from 15 to 35% by weight, based on the binder, the proportion of butadiene present in 1,2-linked form being at least 15% by weight, based on the binder, and the amount of the styrene/butadiene block copolymer is from 35 to 50% by weight and that of the plasticizer is from 25 to 50% by weight, based in each case on the sum of all components of the relief-forming layer.

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- 35 2. A process according to claim 1, wherein the amount of the plasticizer is from 30 to 45% by weight and that of the styrene/butadiene block copolymer is from 35 to 50% by weight, based in each case on the sum of all components of the relief-forming layer.

- 40 3. A process according to claim 1 or 2, wherein the proportion of butadiene which is present in 1,2-linked form in the polymer is at least 20% by weight, based on the binder.

4. A process according to any of claims 1 to 3, wherein the plasticizer is a mixture of plasticizers which comprises at least one polybutadiene oil.
- 5 5. A process according to claim 4, wherein the plasticizer mixture furthermore comprises at least one mineral oil.
6. A process according to claim 4 or 5, wherein at least 40% by weight of the butadiene units in the polybutadiene oil are incorporated in 1,2-linked form.
- 10 7. A process according to either of claims 1 and 6, wherein the relief-forming layer additionally comprises up to 20% by weight of at least one secondary binder.
8. A process according to any of claims 1 to 7, wherein the imagewise exposure (a) is carried out by positioning a mask on the flexographic printing element and effecting exposure to light through the positioned mask.
- 15 9. A process according to any of claims 1 to 7, wherein the flexographic printing element additionally has a digitally imageable layer and step (a) is carried out by recording imagewise on the digitally imageable layer and effecting exposure to light through the mask thus created in situ.
- 20 10. A process according to claim 9, wherein the digitally imageable mask is a mask selected from the group consisting of IR-ablative masks, inkjet masks and thermographic masks.
- 25 11. A process according to claim 9 or 10, wherein the digitally imageable layer or the residues thereof is or are removed from the relief-forming layer before process step (b).
- 30 12. A process according to claim 11, wherein the digitally imageable layer is water-soluble, and the digitally imageable layer or the residues thereof is or are removed with water or a predominantly aqueous solvent before step (b).
- 35 13. A process according to any of claims 1 to 12, wherein the removal of the softened, unpolymerized parts is carried out by bringing the flexographic printing element into contact with an absorbent material.
- 40 14. A process according to any of claims 1 to 12, wherein the removal of the softened, unpolymerized parts is carried out by processing the flexographic printing element with hot air or liquid streams under pressure.

15. A process according to any of claims 1 to 14, wherein the temperature in step (b) is from 60 to 160°C.